	er ID 122648 , 2014 8:42:34 AM		*122	648*	• •					Page 1
Revision ID: Item Name:	D3571-3 Guide		Accept	*N900		100	ገ*	Setup Star	17	S1* S2*
Start Date: Required Date: Reference:	7/21/14 Start Qty: 10.0 7/21/14 Req'd Qty: 10.0	• •		Cust Item Customer:				_		
Approvals:	Process Plan: MUJ	Date: 14-07	-23 Tooling:	D	ate:]	Run Sta	~1 <i>\</i> 1	R1*
	QC:	Date:	SPC (Y/N):	D	ate:	· · · · · ·		Sto	*N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	• .								
D3571	Rev A									•
*1 \\ \A\ \A\ \Bandsaw \\ Jeaspa Bandsaw	BAND SAW Memo Cut blan	k 2.90 " long	0.00				10	Ø	-	14/27/25
110 *110*	HAAS CNC VERTIO	CAL MACHINING #1	0.00				/ -			fish
HAAS 1 HAAS CNC vertical	Memo machine #1 1- Mill a	ıs per Folio FA681 Rev: _	0.00 44 & Dwg D3571 Rev:	2-Deburr			10	3		/14/07/27
d .	per dwg	D3571		·						
120 *120*	QC2- Inspect parts o	ff machine FAI/FAIB · ´	0.00				1.	3		Just
QC	Memo		0.00				-10			

Memo

Quality Control

	0				·							e ·
DQA:	Awt-	Date:	14/0	8/01	WORK ORDER NON	l-CC	ONFO	RMANCE / U	IPDATE			DART
QA Closed: (Date:	14/	8/						ork Order up	odate only	
Work Order	: /	126	40	į	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No	ο. <u>Δ</u> -	357	71-	_ <u>3</u> _	Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube Machining Noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Quality Other
Root				Desc	ription of work order update		nitial		tion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	14/07/2	,110	3	RC tool the the	unfer 0,031 is usinged on 3 pieces. To Re mesured changer and forgot about 1 other offset on same tool / 10	٩	0AS 16 0-89 0204~ 07028	Replo H 1293 SRAP Dest		fish /12/07/31	DAS 16 9-89	DAS 16 9-89 Q72042 14/0/27
						FAI	ULT CA	regory				
Landin	Bending Centre Non Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspectio Marks/Cl	nk/Ripple at in Strip in natter Sequence	e/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislabe Misreae Off-set	ion Incomplete/U ions Incomplete/ gned/off center eled d	Inqualified //	Outside Dim Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	tolerance ct issing Vrong (Surge	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	Wave/Tw	vist in Tub	oe .		Fit/Function		Out of	Sequence				

122648

Page 2

Tuesday, July 22, 2014 8:42:34 AM Accept Item ID: D3571-3 *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Guide *10* **Start Date: Start Qty: 10.00** 7/21/14 **Cust Item ID:** Required Date: 7/21/14 Req'd Qty: 10.00 *10* **Customer:** Reference: Start Run Process Plan: Date:_____ **Approvals: Tooling:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Reject Reject Accept Insp. **Work Center ID Description** Qty **Run Hours** Code Qty Number Stamp 130 QC8- Inspect parts - second check 0.00 37 *130* 10 0.00 Memo Quality Control 140 Chemical Conversion Coat per OSI005 4.1 0.00 10 Hs 4728 *140* HandFinish 0.00 Memo Hand Finishing 150 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00 *150* Powdercoat Memo Powder Coating OVEN TEMPERATURE: START TIME: FINISH TIME

DQA:			Date:			,							TAART
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UPDA		ork Order up	date only	AEROSPACE
						DISPOSITION			,		PARTMENT		
Work Ord	er: -					, , , , , , ,	, أ		and the Co		7	Water Jet	T Fraincaring
Dt. 1						Rework			 	rosstube Small Fab	Bro	d. Eng. Coor.	Engineering Quality
Part N	NO	 				Scrap Use-as-is			~ 	Finishing	4	e/Packaging	Other
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Root				۵.	Desci	ription of work order update	ı	nitial	Action		Sign &	Vanifiaatian	OC Inchestor
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	on	Date	Verification	QC Inspector
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Landi	ng G	Gear				General							
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	П	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ાં _	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqua	lified	Part Lost/Mi	ssing	Weld
8		Cuffs				Contamination		instruc	tions Incomplete/Uncle	ear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned V	_	-
		Heat Trea	at			Cut Too Short		Mislab	eled	L	Power Loss/	Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d				
		Marks/Ch	natter			Drill Holes		Off-set					
		Turning S	Sequence			Finish		Out of	Calibration				
		Wave/Tw	vist in Tub	эе		Fit/Function		Out of	Sequence				

Work Order ID 122648

122648

Page 3

Tuesday, July 22	2, 2014 8:42	2:34 AM		~ /	//h48"					,		Page 3
Item ID: Revision ID: Item Name:	D3571-3 Guide		A	Accept	*N900	040	100)*	Setup	Start Stop	*N:	S1* S2*
Start Date: Required Date: Reference:	7/21/14: 7/21/14	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item ! Customer:	ID:						
Approvals:	Process P	lan:	Date:	Tooling:	D	ate:	_	I		Start	*NI	२ 1*
T.	·QC:		Date:	SPC (Y/N):	D	ate:				Stop	*NI	₹2*
Sequence ID/ Work Center II 160 *160* QC Quality Control	D	Operation Description QC3- Inspect Part Finish Memo Identify as per dwg & Sto	ck Location: <u>5T0</u> 5C	Set Up/ Run Hour: 0.00 DAS 38 0.00 0.00	Tool ID s	Tool#	Plan Code	Accept Qty	<i>y</i> :		Reject Number	Insp. Stamp DAS 9 9-89
Packaging 180 *1 A \ QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00						ſι	1112	19 D

JA4-7-29

DQA:			Date:			. WORK ORDER NON	~	281501					*DART
QA Closed:	į.		Date:			WORK ORDER NON	-C(JNFU	RIVIAINCE / UF		ork Order up	date only	AEROSPACE
Work Orde	ır.				·	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
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Root					Desc	ription of work order update		nitial	Acti	ion	Sign &		
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Offset/Setup													
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Unapproved			<u> </u>	<u> </u>	L		ΕΛΙ	III T CA	TEGORY		<u> </u>		
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	-	Crimp/Kii	nk/Rinnle	/Wave		Burrs		-	ion Incomplete/Un	ngualified -	Part Lost/M	_	Weld
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	—	Marks/Ch	•		-	Drill Holes		Off-set					
	_	Turning S				Finish		-	Calibration				
	—	Wave/Tw	-			Fit/Function		Out of	Sequence				

Picklist Print

Tuesday, July 22, 2014 8:42:33 AM

Work Order ID: 122648

122648

Parent Item:

D3571-3

D3571-3

Parent Item Name: Guide

Start Date: 7/21/14

Required Date: 7/21/14

Page 1

Start Qty: 10.00

Required Qty: 10.00

Comments:

1

IPP Rev:A New Issue 07-02-01 JLM

IPP Rev:B Remove manual Machinig 08-05-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50		Purchased	No	•	110	f	41.9470	0.241	2.536842			

M6061T6B0 750X01 500

6061-T6 Bar .750 X 1.50

**

Loc Code Location Loc Qty MAT001 41.947 129375 38.627 m127818 1.3 m128247 1.27 m128866 0.75

DQA:			Date:								•		189	DART
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			_	_	AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	`r·					DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS		
work Orde	٠					Rework	1		Skid-tube Crosstub	_ ا	1	Water Jet	٦ _{Fr}	ngineering
Part N	d n					Scrap			Machining Small Fa	⊢	Pro	d. Eng. Coor.	┨ -	Quality
· u···	•••					Use-as-is		ì	noforming Finishin	-	-{	re/Packaging		Other
NCR N	No.				•	Suspected Unapproved			Large Fab Composit	e]	Supplier		
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Root					Desc	ription of work order update	ı	Initial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification		QC Inspector
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	Ť	Bending		•		Bend		Folio/F	Program	L	Outside Dim	ensions	Pres	ssure/Forced
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		Cracks				Broken/Damage/Defect		Hardwa	are	L	Part Incorre	cí L		perature/Cure
		Crimp/Kiı	nk/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	issing	_ Wel	
,		Cuffs				Contamination		⊣	tions Incomplete/Unclear	L	Part Moved	L	Wro	ong Stock Pulled
		Crushing				Countersink		-1 '	gned/off center	L	Positioned V		—	
		Heat Trea	at		L	Cut Too Short		Mislab		L	Power Loss/	Surge	Oth	er
	L	Inspectio		Tube	<u> </u>	Drawing		Misrea						
	L	Marks/Cl				Drill Holes		Off-set						
	L	Turning S				Finish	L	4	Calibration		-			
		Wave/Tw	vist in Tul	be		Fit/Function		Out of	Sequence					

DART AEROSPACE LTD	Work Order:	122648
Description: Guide	Part Number:	D3571-3
Inspection Dwg: D3571 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
	· · · · · · · · · · · · · · · · · · ·

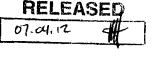
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	0 695			MJP-04	Vern
2.75	+/-0.030	2 748	1/		,,,	11,
1.38	+/-0.030	1373			1	
1.25	+/-0.030	1251	1			
0.63	+/-0.010	0624				
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0.260	+0.000/-0.010	0258				Pin Carre
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0.125	+/-0.010	0126			,,,	. 1 \
2.250	+/-0.010	2 252	1/			
0.250	+/-0.010	0146				
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0.063 chamfer	+/-0.010	0,063	V		4	•

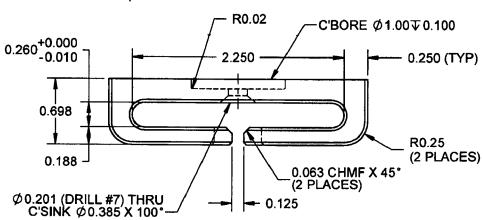
			DAS		
Measured by:	Mosp	Audited by:	37 9-83	Prototype Approval:	N/A
Date:	14/07/26	Date:	14.07.27	Date:	N/A

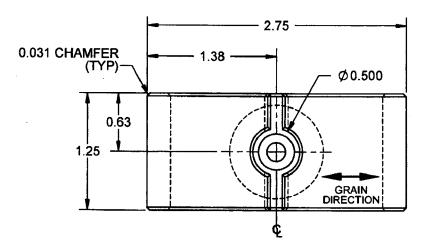
Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM A	Gill .

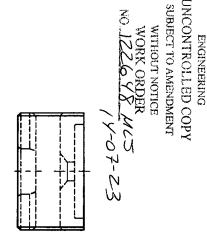


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	CHECK	KED	APPROVED	DRAWING NO.	REV. A
	<u> </u>	<u> </u>		D3571	SHEET 1 OF 2
1	DATE		10	TITLE	SCALE
	07.01.29			GUIDE	1:1
٦	REV	REV DATE		DESCR	IPTION
Į	Α		07,01.29	NEW ISSUE	









D3571-1 GUIDE

1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR

PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

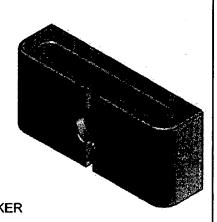
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

7) PART IS SYMMETRIC ABOUT Q

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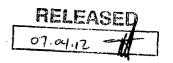
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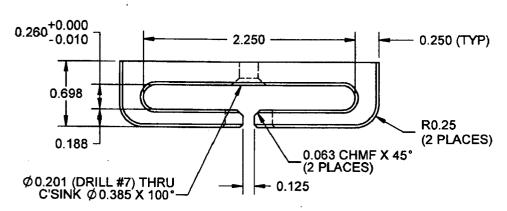


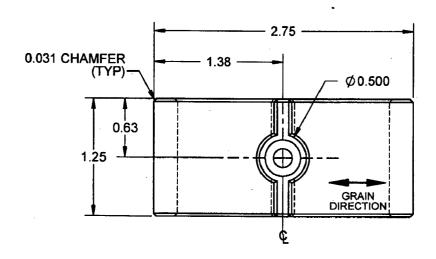
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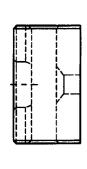


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DATE)1.29	TITLE GUIDE	SCALE 1:1









D3571-3 GUIDE

NOTES

1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR

PER QQ-A-225/8 OR AMS 4117/4128/4115/4116

OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

7) PART IS SYMMETRIC ABOUT &

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